

Date: Tuesday, 28/04/2009 12:38:14 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STRUT ASSEMBLY	
<b>Job Number</b> :	47563			
<b>Estimate Number</b> :	10732			
<b>P.O. Number</b> :		<b>Part Number</b> :	D2324	
<b>This Issue</b> :	28/04/2009	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2324 REV. C	
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	45886	<b>Drawing Revision</b> :	C	
<b>Written By</b> :		<b>Material</b> :		
<b>Checked &amp; Approved By</b> :	JUD 09.04.28	<b>Due Date</b> :	01/05/2009	<b>Qty:</b> 20 <b>Um:</b> Each
<b>Comment</b> :	Est: E 03.02.28 Reformat, Incorporated D2324-3 & D2324-5 K J/RF			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	47563A	STOP
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**Comment:** Sub-Component STOP

1 x D2324-3 Batch

B47563

Ep09/05/04

2.0	47563B	STRAP
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**Comment:** Sub-Component STRAP

2 x D2324-5 Batch

B46324

Ep09/05/04

3.0	AN312A	Bolt
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

M1109297

Ep09/05/04

4.0	AN960JD10	Washer
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

M110985

Ep09/05/04

5.0	MS21042L3	Nut
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

M110844

Ep09/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 47563

Part Number: D2324

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D2324.

*Eff 09/05/04 (20)*  
*S 09/05/04 (20)*  
*counts*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

*7:15*

OVEN TEMPERATURE:

*320°*

FINISH TIME:

*7:45*

*FL 09/05/06*

*(20)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*09-05-06*

*(20)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *S11*

*9/5/7*

*(20)*

*80*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/05/07*

Job Completion



*MF*  
*09-05-07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

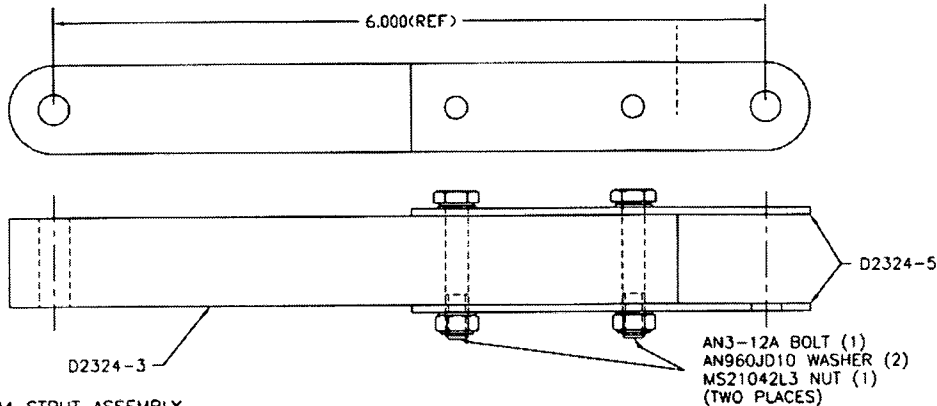
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

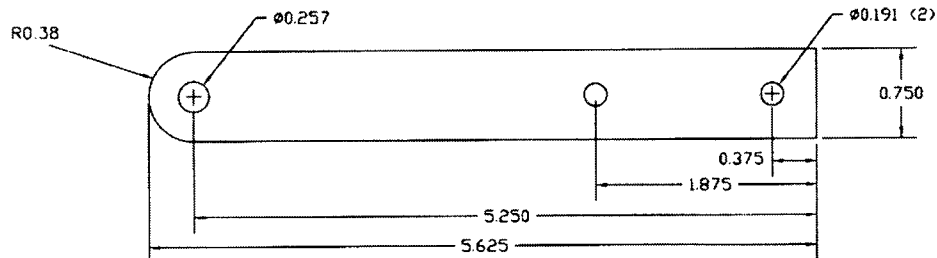
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. C
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2324	SHEET 1 OF 1
DATE	TITLE		
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

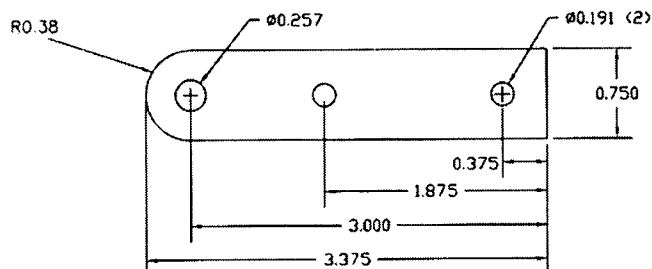
REL 104.12.16 *[Signature]*

**D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O 47 563